

Date: Tuesday, 09/10/2007 2:55:19 PM
 User: Linda L. acelle

Process Sheet

Split #3

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 35032-3
 Estimate Number : 12884
 P.O. Number : N/A Part Number : D3560044
 This Issue : 09/10/2007 S.O. No. : N/A Drawing Number : D3560 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C
 Previous Run : 35032 Material : N/A
 Due Date : 19/10/2007 Qty: 10 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07.05.24 EC
 Est Rev B ECN 987 07.10.09 EC verified by DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total : 13.5975 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: 3105950

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: 4/1 & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35032

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

PLATE

3 34478

07.11.08

5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (65°C)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07/11/14

Date: Tuesday, 09/10/2007 2:55:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35032

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 07/11/14 (5)

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

batch: B35330

MF 07-11-15

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

MF 07-11-15

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-11-15 (5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST152

U (X5) AS 07/11/15

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5) 07/11/15

Job Completion



U 07.11.15

DART AEROSPACE LTD		Work Order:	35032
Description: Arm		Part Number:	D3560-4
Inspection Dwg: D3560	Rev: <i>LC</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

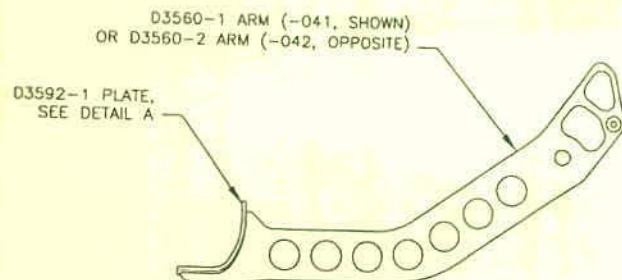
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	<i>0.505</i>	✓			
Ø0.196	+0.005/-0.001	<i>0.197</i>	✓			
Ø1.000	+0.010/-0.001	<i>1.003</i>	✓			
Ø0.900	+0.010/-0.001	<i>0.900</i>	✓			
0.500	+/-0.010	<i>0.496</i>	✓			
0.250	+/-0.010	<i>0.248</i>	✓			
0.275	+/-0.010	<i>0.276</i>	✓			
0.188	+/-0.010	<i>0.192</i>	✓			
2.000	+/-0.010	<i>2.000</i>	✓			
1.750	+/-0.010	<i>1.750</i>	✓			
1.702	+/-0.010	<i>1.705</i>	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	<i>0.385 x 100°</i>	✓			
0.250 Deep	+/-0.010	<i>0.248</i>	✓			

Measured by:	<i>SK</i>
Date:	<i>02-10-2017</i>

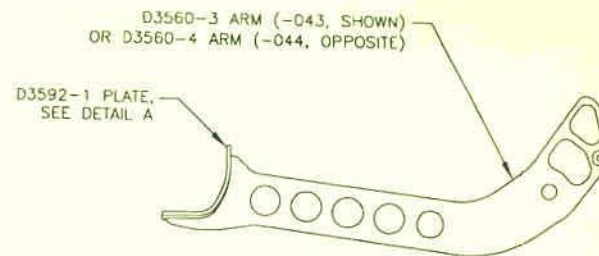
Audited by:	<i>TL</i>
Date:	<i>04/10/17</i>

Prototype Approval:	N/A
Date:	N/A

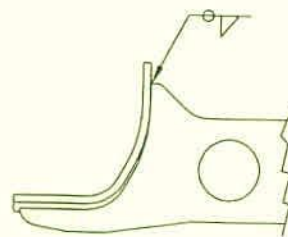
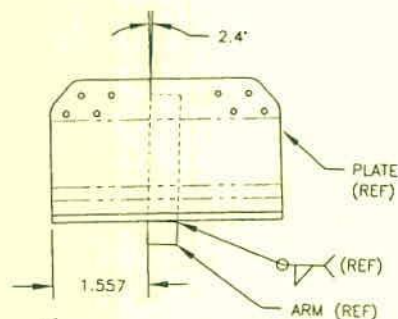
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM <i>JA</i>	<i>BE</i>



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

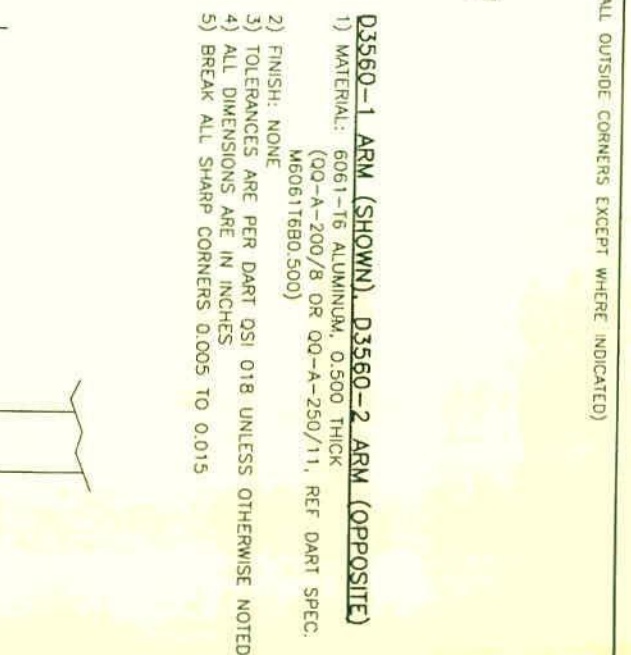
RELEASED
07.06.19

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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	q	DART AEROSPACE LTD. WARRICKBURT, ONTARIO, CANADA
CHECKED	q	DRAWING NO. D3560
DATE	07.06.19	TITLE ARM WELDMENT
		REV. C SHEET 1 OF 3 SCALE 1:4



0.186
R0.30 (TYP ALL OUTSIDE CORNERS EXCEPT WHERE INDICATED)

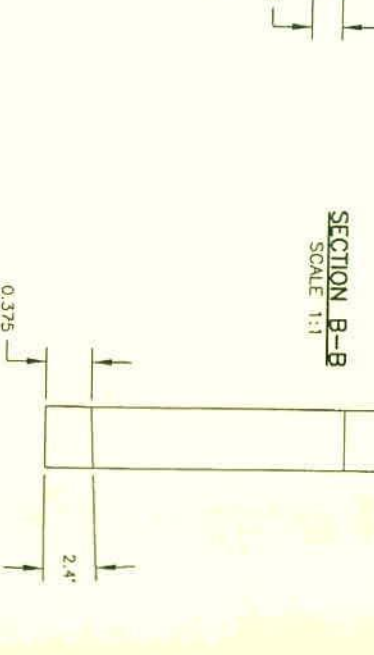
PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4',
SEE SECTION B-B

C'BORE $\phi 0.507^{+0.000}_{-0.001}$
0.250 DEEP FROM
THIS SIDE

D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)
1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK

(00-A-200/8 OR 00-A-250/11, REF DART SPEC.
M60611680.500)

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART DSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

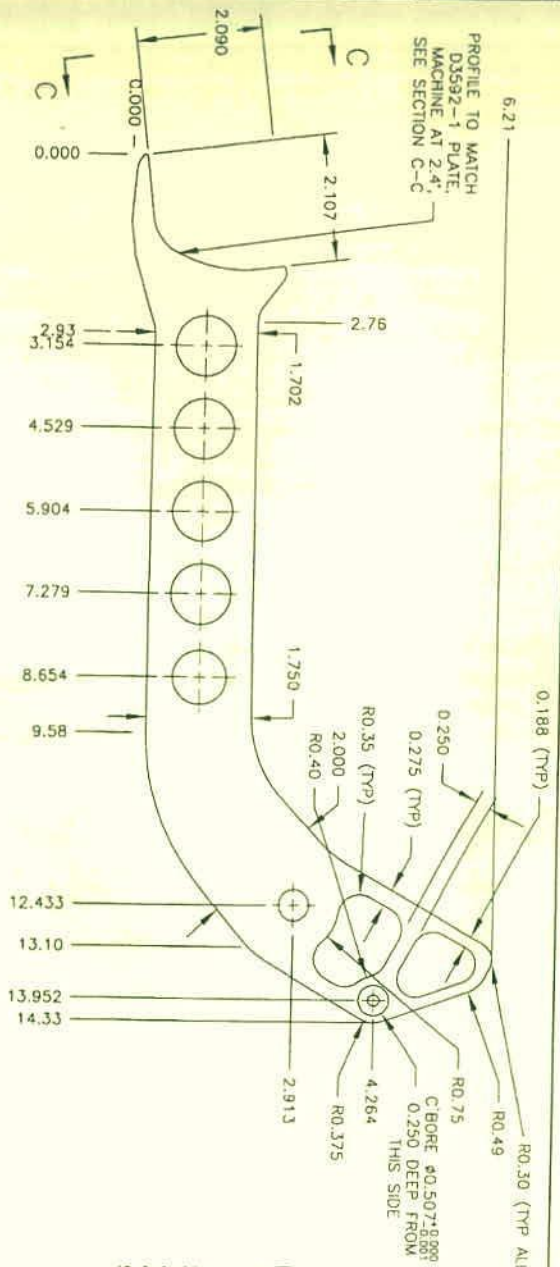


SECTION B-B
SCALE 1:1

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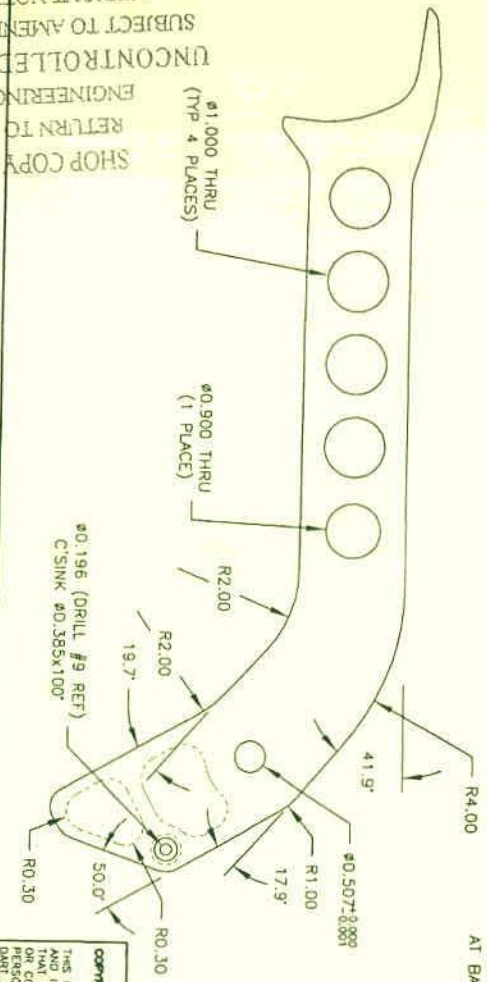
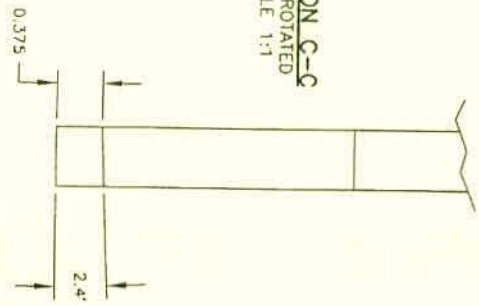
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DESIGN DATE: 07.06.19	DRAWN BY CHECKED: <i>[Signature]</i> APPROVED: <i>[Signature]</i>	DART DRAWING NO. D3560	DART AEROSPACE LTD. HANOVER, OHIO, OHIO
TITLE ARM WELDMENT	SCALE 1:2	REV. C SHEET 2 OF 3	

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- D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK (00-A-200/8 OR 00-A-250/11, REF DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION C-C
VIEW ROTATED
SCALE 1:1



DESIGN		DRAWN BY		DATE	
q		q		07.06.19	
CHECKED		APPROVED		TITLE	
q		q		D3560	
DATE		SHEET 5 OF 3		SCALE	
07.06.19		ARM WELDMENT		1:2	

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07.06.19

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